

Date: Monday, 8/13/2007 3:45:19 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HINGE BRACKET		
Job Number	33882					
Estimate Number	10224					
P.O. Number	N/A		Part Number	D2143		
This Issue	8/13/2007	S.O. No. N/A	Drawing Number	D2143 REV. C1		
Prsh Rev.	NC		Project Number	N/A		
First Issue	N/A	Type	Drawing Revision	C1		
Previous Run	31781		Material	N/A		
Written By	<i>JLM 07-08-13</i>		Due Date	8/20/2007 Qty: 50 Um: Each		
Checked & Approved By						
Comment	Est C 00.05.18 Added inspection level 8 Est Rev:D Now on WaterJet 06-10-15 JLM					

## Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet 
Comment: Qty.: 0.0693 sf(s)/Unit Total : 3.4650 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Batch: M104921 RB 07 - 08 - 14		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D2143 Dwg Rev: C1 RB 07-08-14 Prog Rev: C1		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  RB 07-08-14
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK  Cn 07/08/14 X52		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr → SAM 07/08/14 52 "cont'd"		

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33882

Part Number: D2143

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SB 07/08/20

S2

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/20

QC5

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ

07-08-24

50

9.0 POWDER COATING POWDER COATING



M105068

50X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MJ

07/08/28

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/8/28 5A

50X

07/08/28

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST210

6 7/8/28 5C

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 07/08/30

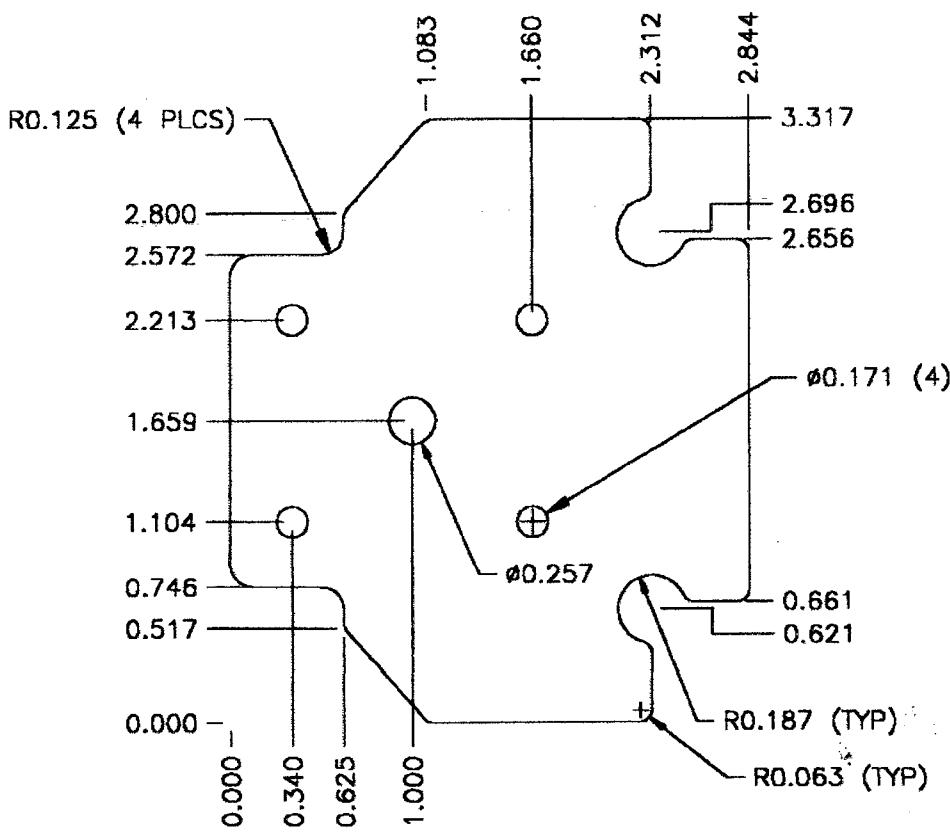
U 07/08/30

Job Completion

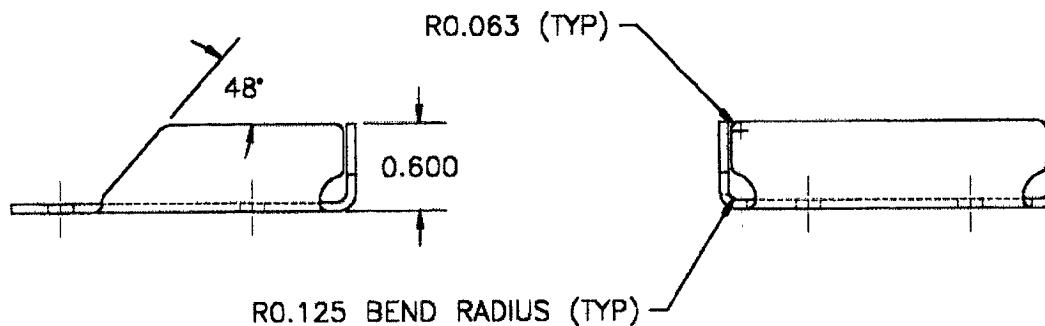
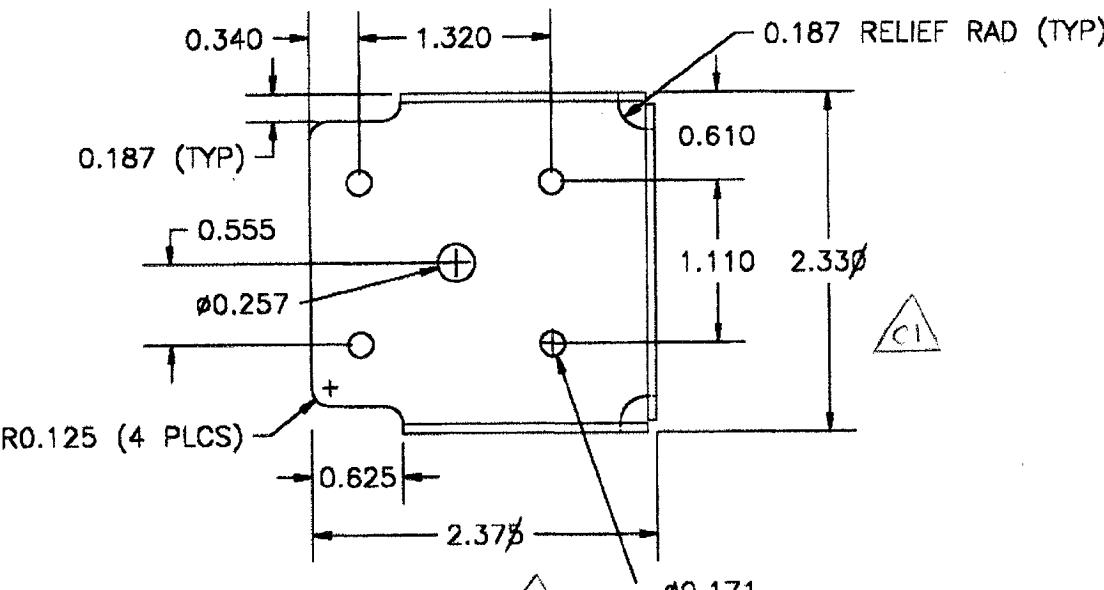


**DART**

DESIGN J. BRADLEY	DRAWN BY K. HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bon</i>	APPROVED <i>Bon</i>	DRAWING NO. D2143	REV. a SHEET 2 OF 2
DATE 95:10:18		TITLE HINGE BRACKET FLAT PATTERN	SCALE 1:1

**RELEASED**  
9L 66 20 fw  
45°

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317



MATERIAL: 5052-H34, 0.040 THICK  
FINISH: WHITE POWDER COAT HI-GLOSS

**RELEASED**  
*(6/06/92 Rev)*

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD	
J. BRADLEY	K. HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
B. C.	B. C.	D2143	SCALE
DATE		TITLE	
92:07:10		HINGE BRACKET	
C1	A/C 04.06.15	UPDATE DIMENSIONS	
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	

DART AEROSPACE LTD	Work Order:	
Description: Hinge Bracket	Part Number:	D2143
Inspection Dwg: D2143      Rev: C1		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article | Prototype

103

Measured by:	<u>VB</u>	Audited by:	<u>EP</u>	Prototype Approval:	N/A
Date:	07-08-14	Date:	07/08/14	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.11.11	New Issue	KJ/JLM <del>✓</del>	<i>Jill</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/14 07/08/14	21	Change grain direction on Drawing D2143 of 45° not along 3.317				✓ 07/08/14	EN 07/08/14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/08/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries